

Friday, May 27, 2011 10:56:58 AM



Accept

**Setup Start**

Stop



Start Date: 6/2/2011 **Start Qty:** 6.00

**Cust Item ID:**

Required Date: 6/6/2011 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: Date: 11-05-27

Tooling:

Date:




Stop



QC:

Date: _____ **SPC (Y/N):** _____

Date:

100		BAND SAW	0.00			
	Bandsaw	Memo	0.00	amh 11/06/09	6	10
	Jeaspa Bandsaw	Cut blanks: 3.250" x 2.500" x 4.250" long Bar (+0.030/-0.000)				
110		HAAS CNC VERTICAL MACHINING #1	0.00			
	HAAS I	Memo	0.00	amh 11/06/10	6	10
	HAAS CNC vertical machine #1	Machine D3205-1 as per Folio FA346 and Dwg D3205 <input type="checkbox"/> Identify as D3205-1 <input type="checkbox"/> Deburr and Tumble				
120		QC2- Inspect parts off machine FAI/FAIB	0.00			
	QC	Memo	0.00	amh 11/06/10	6	10
	Quality Control					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 70127

Friday, May 27, 2011 10:56:58 AM



Page 2

Item ID:	D3205-1	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Pedal Bracket					
Start Date:	6/2/2011	Start Qty:	6.00	Cust Item ID:		
Required Date:	6/6/2011	Req'd Qty:	6.00	Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		MA	11/06/14	6	0		
140 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				6	0	11/06/14	
150 Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 Memo	0.00 0.00				6x	0	11/06/14	

Note: Cover the thread hole for D3205-1 before powder coat. ☐ START TIME: 11:30 ☐ OVEN TEMPERATURE: 320 ☐ FINISH TIME: 12:00

M116128

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 70127

Friday, May 27, 2011 10:56:58 AM



Page 3

Item ID: D3205-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Pedal Bracket

Start Date: 6/2/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 6/6/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

6 BF 11-6-14

170

Identify as per dwg & Stock Location: GA

0.00



Packaging

Memo

0.00

Packaging

ES 11/06/15 @

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/6/15 J
11-06-15 @

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, May 27, 2011 10:57:05 AM

Page 1

Work Order ID: 70127



Parent Item: D3205-1



Parent Item Name: Pedal Bracket

Start Date: 6/2/2011

Required Date: 6/6/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP A 04.06.09 New issue KJ/RF
IPP Rev:B 08-12-16 attach DEO DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M7075T73B2.500X03.2 5		Purchased	No			100	f	10.5000	0.3646	2.302737			



7075-T73 Bar 2.50 x 3.25

Location

Loc Qty

Loc Code

MAT008

10.5

116680

10.5

2.31

inf 10/6/09

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

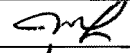
NOTE: Date & initial all entries


DART AEROSPACE LTD		Work Order:	70127
Description: Pedal Bracket		Part Number:	D3205-1
Inspection Dwg: D3205 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.100	+/-0.010	1.103	—		Vern ML-7	
0.250	+/-0.010	.250	—		"	
R0.37	+/-0.030	R.375	—		R-6	
0.125	+/-0.010	.131	—		Vern ML-7	
0.250	+/-0.010	.257	—		"	
2.380	+/-0.010	2.378	—		"	
1.380	+/-0.005	1.379	—		"	
0.500	+/-0.005	.499	—		"	
0.880	+/-0.010	.881	—		"	
Ø0.470 x 100°	+0.005/-0.000	Ø.475 x 100°	—		"	
0.440	+/-0.005	.440	—		"	
0.600	+/-0.005	.598	—		"	
1/4-28UNF-313	N/A	1/4-28UNF-313	—		"	
0.250	+/-0.010	.251	—		"	
Ø0.257	+0.005/-0.000	Ø.259	—		"	
1.750	+/-0.010	1.752	—		"	
0.870	+/-0.005	.870	—		"	
0.440	+/-0.005	.440	—		"	
R0.25	+/-0.030	R.250	—		R-6	

Measured by:		Audited by:	BA	Prototype Approval:	N/A
Date:	11/06/14	Date:	11/06/14	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.02.17	New Issue	KJ/JLM	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

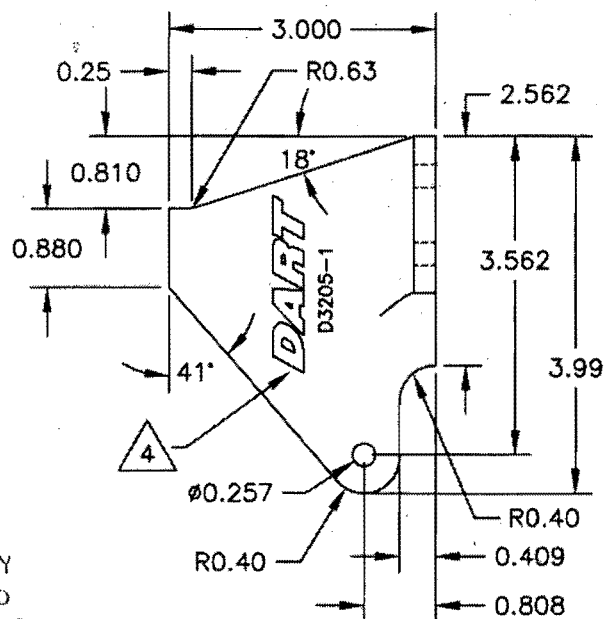
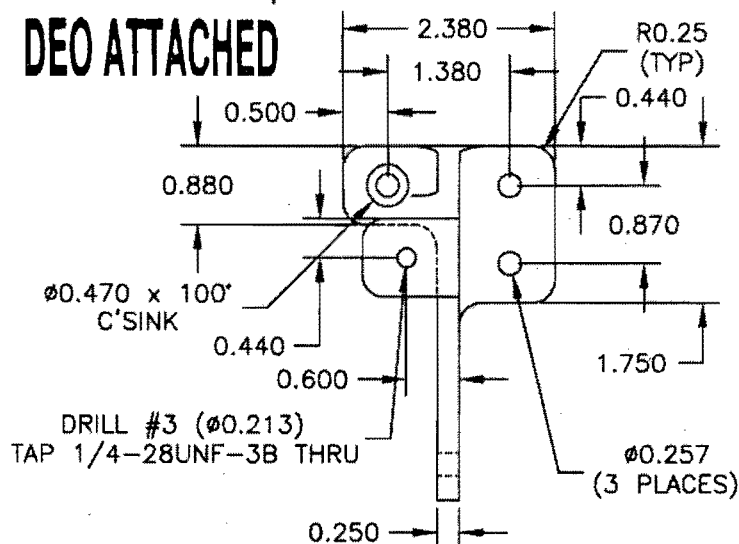
NOTE: Date & initial all entries



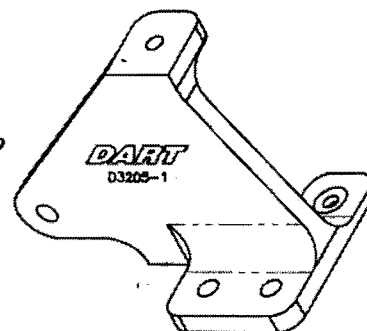
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3205	REV. A SHEET 1 OF 2
DATE 04.01.27	TITLE BRACKET		SCALE 1:2
A	04.01.27	NEW ISSUE	

RELEASED
04.04.05

DEO ATTACHED



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 70127
11/05/27



D3205-1 PEDAL BRACKET

NOTES:

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 7075-T73 (QQ-A-200/11 OR QQ-A-250/12)
OR 2024-T3 (QQ-A-200/3 OR QQ-A-250/4)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) ENGRAVE DART P/N & LOGO AS SHOWN
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE INCHES

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

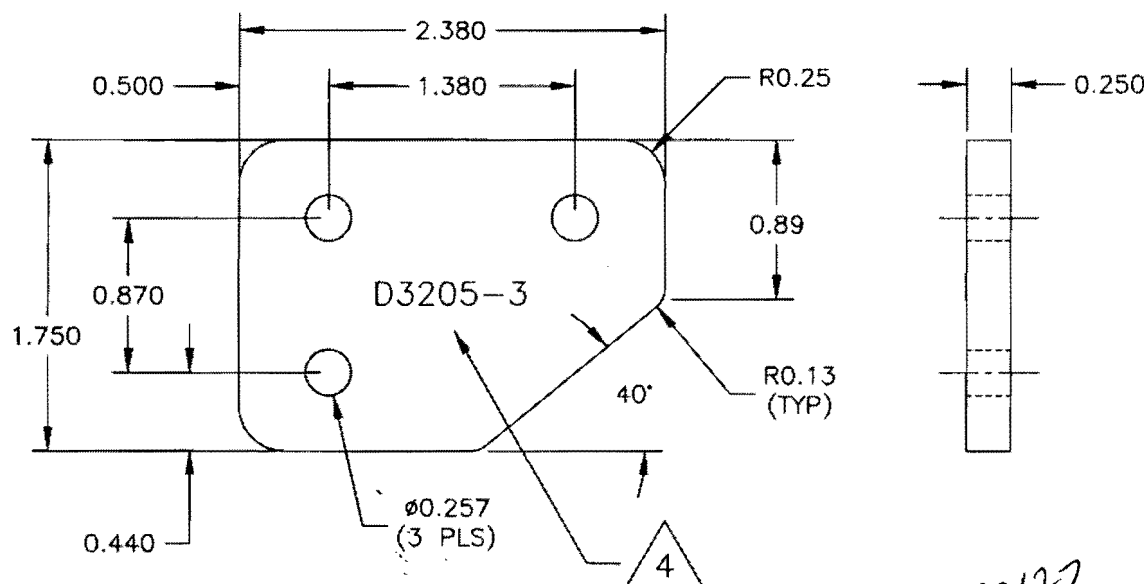
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
74	74	DRAWING NO.	REV. A
CHECKED	APPROVED	D3205	SHEET 2 OF 2
DATE		TITLE	SCALE
04.01.27		BRACKET	1:1

RELEASED
04.04.05**DETACHED****D3205-3 BACK PLATE****NOTES:**

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8)
ALUMINUM BAR (M6061T6B)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) ENGRAVE DART P/N AS SHOWN
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE INCHES

w/o 70127

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

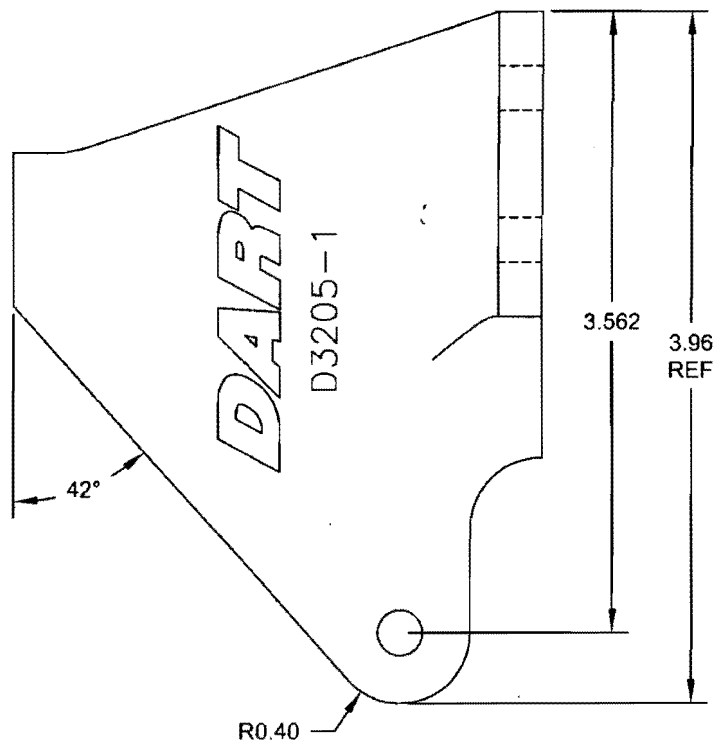
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NOTE: Date & initial all entries

DRAWING NO. D3205	TITLE BRACKET	REV. A	DART AEROSPACE LTD ENGINEERING ORDER	D.E.O. NO. D3205-A-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN AJS	CHECKED	MFG. APPR.	APPROVED	DE APPR.		
DATE 08.12.01	DATE 08.12.01	DATE 08/12/01	DATE 08/12/01	DATE 08.12.01		

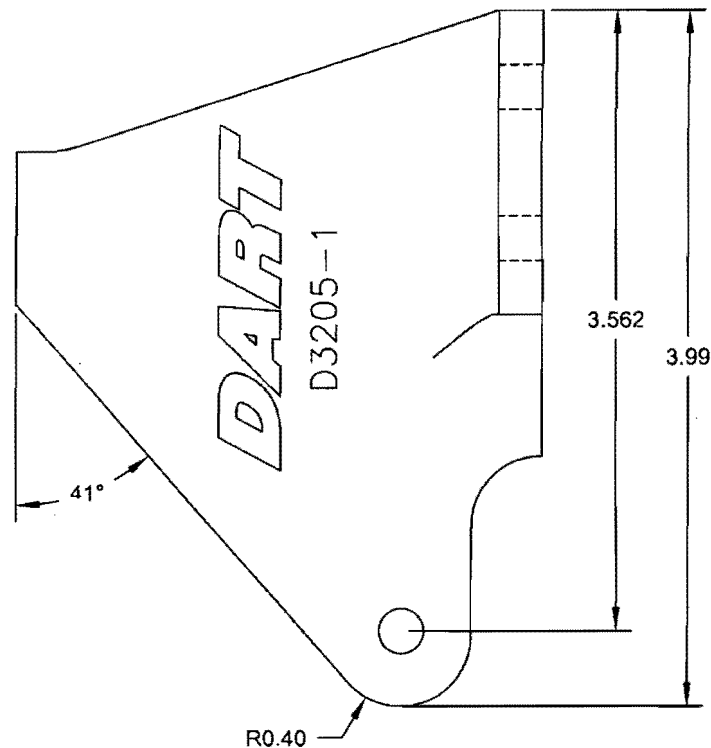
SHEET 1 MODIFY D3205-1 AS SHOWN:

IS:



WAS:

w/o 70127



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries